

Date: Tuesday, 10/2/2007 10:39:39 AM
 User: Kim Johnston

Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING ANGLE
 Job Number : 34933
 Estimate Number : 10509
 P.O. Number : N/A Part Number : D2564
 This Issue : 10/2/2007 S.O. No. : N/A Drawing Number : D2564 REV. B1
 Prsht Rev. : NQ Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1
 Previous Run : 32460 Material : N/A
 Due Date : 10/8/2007 Qty: 40 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6207 Angle Extrusion 1x1x.125



Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207)

Batch: ~~32460~~ 327538

DJP 07/12/05

2.0 BAND SAW

BAND SAW



Comment: BAND SAW

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

DJP 07/12/05

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA276 and Dwg D2564

Tumble and Deburr

Identify as D2564

DJP 07/12/10

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/12/10

40

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

07/12/12

S.F. 07/12/11

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/12/13	3	ADD line for photo rev & drug rev.	AA	07/12/13			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 34933

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 836

Co 7/12/12 (40)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

40
D 07/12/13

Job Completion



min 2007/12/12 CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

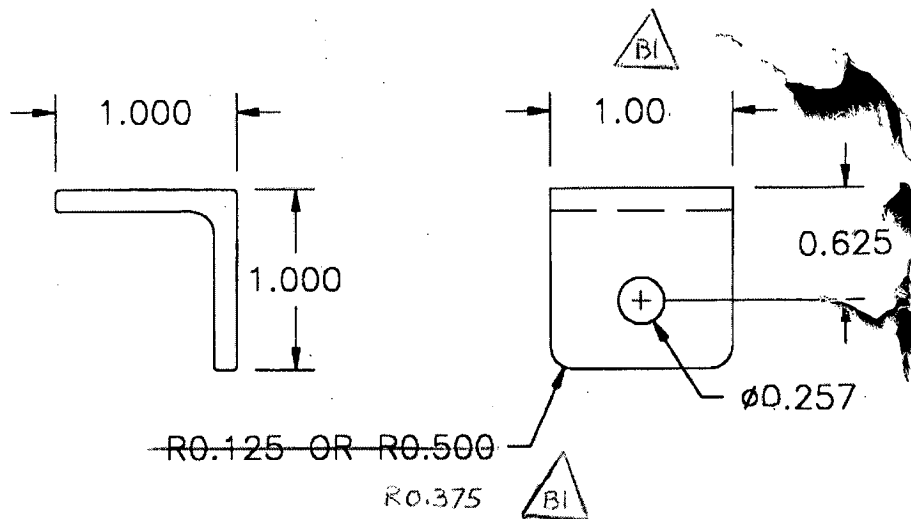
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. B
CHECKED BW	APPROVED BW	D2564	SHEET 1 OF 1
DATE	TITLE		SCALE
96:04:30	MOUNTING ANGLE		1:1
B	97:05:06	MODIFIED DIMENSIONS	
BI	RF 02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

RELEASED
(97/05/06 BW)



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION.
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34933

